

Work Order ID 70497

Friday, June 10, 2011 8:57:20 AM

Page 1

Item ID: D3027-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Clip

Start Date: 6/10/2011 Start Qty: 16.00

Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 16.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 11-06-10 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3027	Rev B								

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3027

NOTE GRAIN DIRECTION**

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B11-6-10

(20)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 6/13/2011 Req'd Qty: 16.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

Memo

130



Brake NC

Brake NC

NC BRAKE

0.00

0.00

Memo

Debur if necessary

Form as per Dwg D3027

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

S 11/06/13

count
x20

28

count
x20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3027-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Clip

Start Date: 6/10/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

20 0 11-6-13.

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 0 11-6-13

170

Identify as per dwg & Stock Location: 031

0.00



Packaging

Memo

0.00

Packaging

20 0 11-6-13 (20)

Work Order ID 70497

Friday, June 10, 2011 8:57:20 AM



Page 4

Item ID: D3027-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Clip

Start Date: 6/10/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

6/13/11

CL 6/10/11

Picklist Print

Friday, June 10, 2011 8:57:17 AM

Page 1

Work Order ID: 70497



Parent Item: D3027-7



Parent Item Name: Clip


Start Date: 6/10/2011

Required Date: 6/13/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP C05.10.07 Added forming step and Issue P/O KJ/JLM
IPP Rev:B Now on WaterJet 08-12-08 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050 		Purchased	No			100	sf	122.8000	0.024	0.404211	15		

2024-T3 .050 sheet



16-6-10

Location

Loc Qty

Loc Code

MAT22

122.8

117684

122.8

117684

20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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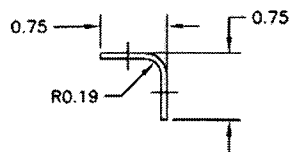
NOTE: Date & initial all entries



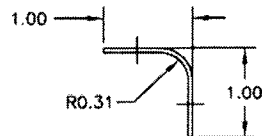
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3027	REV. B SHEET 1 OF 2
DATE 05.09.20		TITLE CLIP	SCALE 1:2
A	01.05.18	NEW ISSUE	
B	05.09.20	REMOVE HOLES FROM -7	

RELEASED

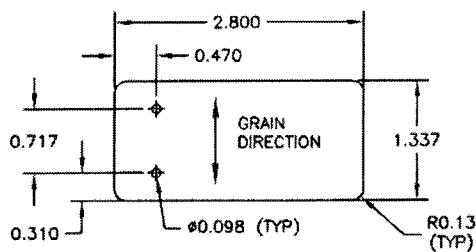
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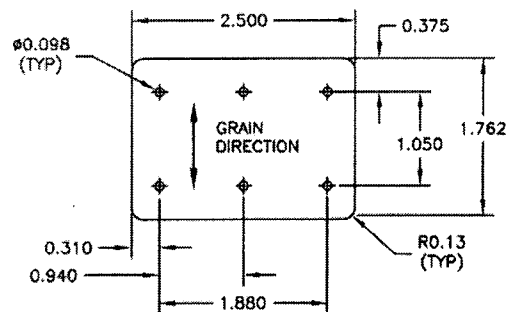
D3027-1 BEND DETAIL



D3027-3 BEND DETAIL



D3027-1 FLAT PATTERN
(0.063" SHEET)



D3027-3 FLAT PATTERN
(0.050" SHEET)

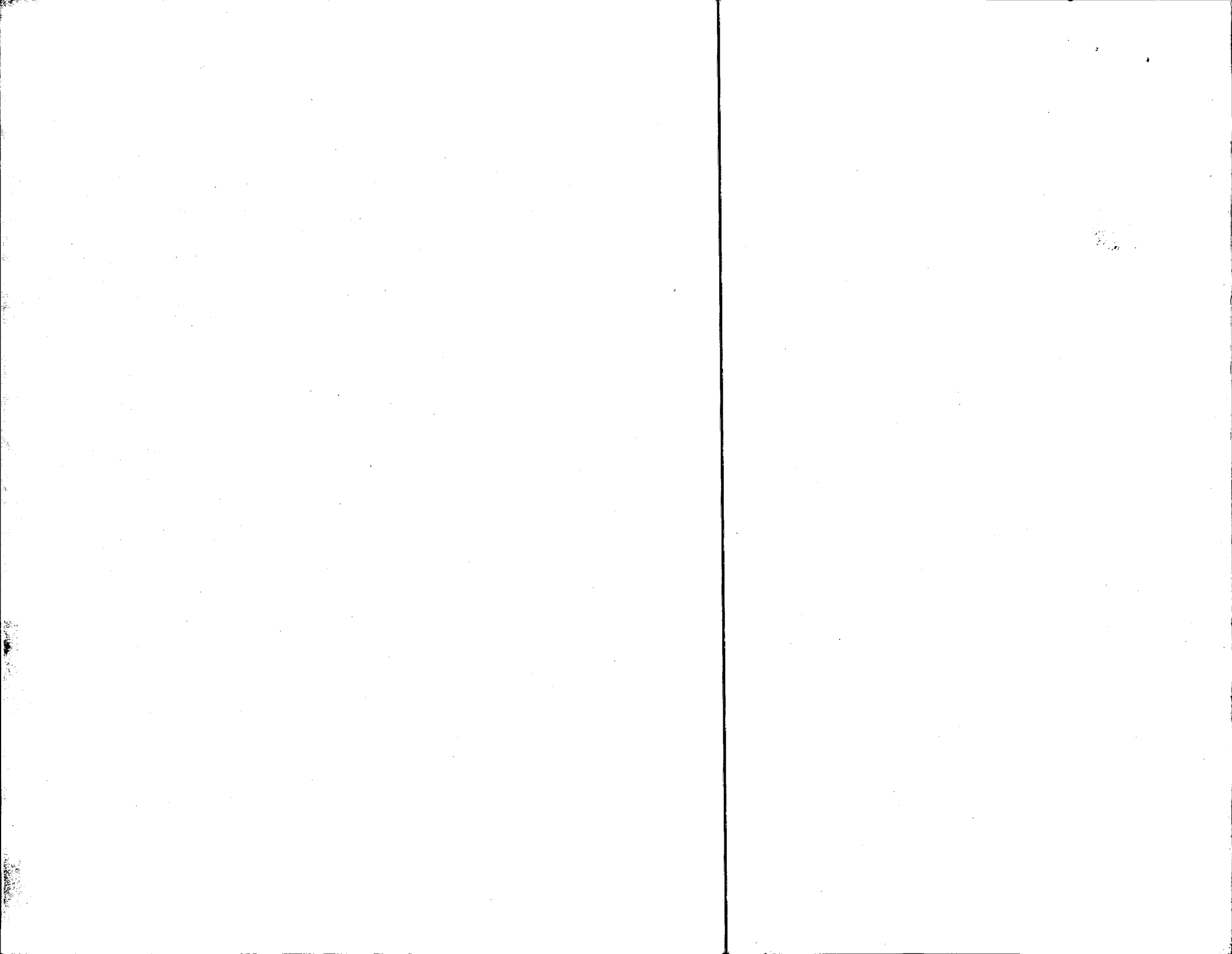
NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

#10497

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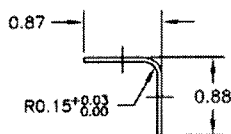
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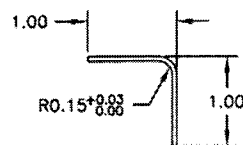


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DATE 05.09.20		TITLE CLIP	SCALE 1:2

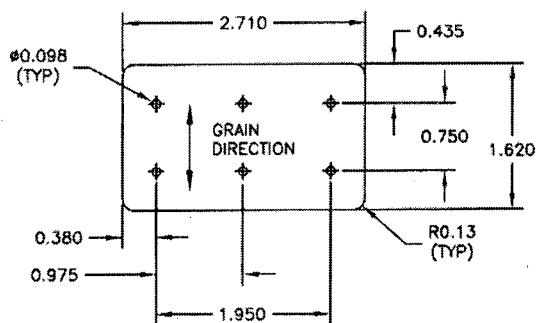
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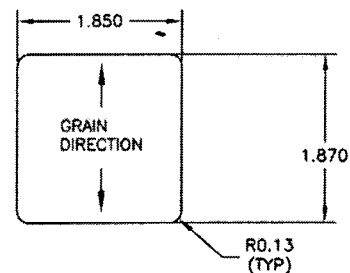
D3027-5 BEND DETAIL



D3027-7 BEND DETAIL



D3027-5 FLAT PATTERN
(0.050" SHEET)



D3027-7 FLAT PATTERN
(0.050" SHEET)

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